

Date: Monday, 23/02/2009 3:30:06 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING LUG
Job Number : 46022	
Estimate Number : 13267	
P.O. Number :	Part Number : D37071
This Issue : 23/02/2009 S.O. No. :	Drawing Number : D3707 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 44726	Material :
Written By :	Due Date : 15/03/2009 Qty: 12 Um: Each
Checked & Approved By : <u>JUD 09-02-24</u>	
Comment : Est Rev:A New Issue 08-04-16 JLM Verified By:EC Est Rev:B 09-02-20 rev.b as per dwg DD verified by:EC	

Additional Product:

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELINB1250X2500	Delrin Bar 1.250"X 2.500"
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Delrin Bar
 2.000 X 3.000

Comment: Qty.: 0.2363 Ft(s)/Unit Total: 2.8350 Ft(s)

Delrin Bar 1.250"X 2.500"

BATCH: M107758 X 2 PLS

M108068 X 10 PLS

J.F. 09/03/03

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank 2.700" long

J.F. 09/03/03 (12)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1 HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA737 Rev: AA & Dwg D3707 Rev: B

2-Deburr per dwg D3707 and countersink .5625" ON DRILL PRESS

J.F. 09/03/03 (12)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/03/03 (12)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JL 09/03/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/02/2009 3:30:06 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 46022

Part Number: D37071

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 118

9/3/4

121

SP

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/05

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-03-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46022
Description: Mounting Lug		Part Number: 3707-1
Inspection Dwg: 3707 Rev: B		Page 1 of 1

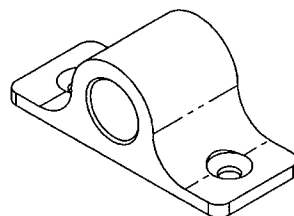
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

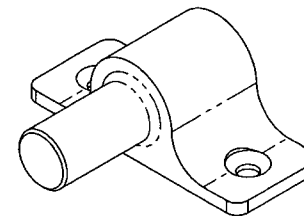
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50"	$\pm .030$	2.500"	✓			
1.750"	$\pm .010$	1.753"	✓			
.38"	$\pm .030$.374"	✓			
R0.13"	$\pm .030$	R.130"	✓			
.500"	$\pm .010$.500"	✓			
1.00"	$\pm .030$.999"	✓			
Ø.201"	$\pm .005$	Ø.201"	✓			2 PL
CSK Ø.385 x 100°	$\pm .010$	Ø.375"	✓			2 PL
.03 x 45°	$\pm .030$.030"	✓			
R0.48"	$\pm .030$	R.475"	✓			
Ø.563"	$\pm .001$	Ø.563"	✓			THRU
R0.38"	$\pm .030$	R0.375"	✓			
.125"	$\pm .010$.126"	✓			
1.250"	$\pm .010$	1.249"	✓			
.500"	$\pm .010$.501"	✓			
.98"	$\pm .030$.975"	✓			

Measured by: J.F.	Audited by: J.L.	Prototype Approval:	N/A
Date: 04/03/03	Date: 09/03/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3707-1 MOUNTING LUG



D3707-3 MOUNTING LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 140028

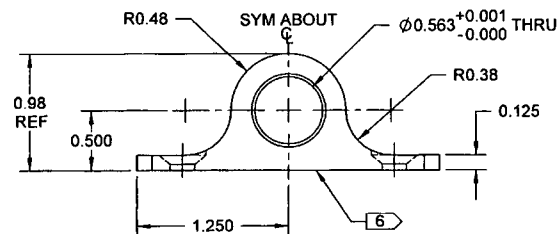
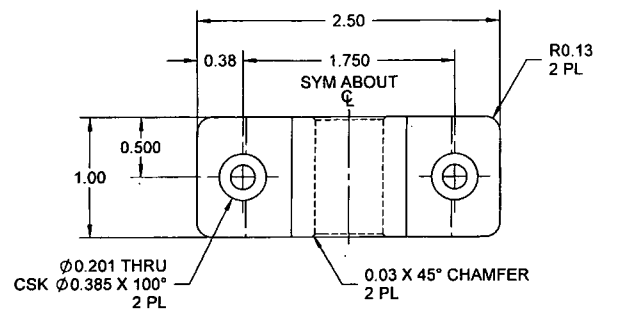
RELEASED
07/04/05

NOTES:

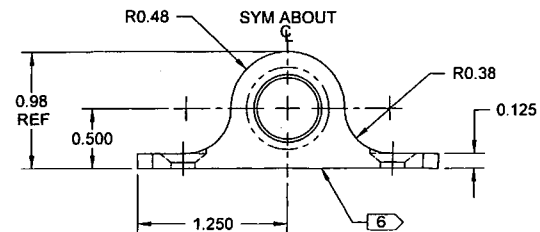
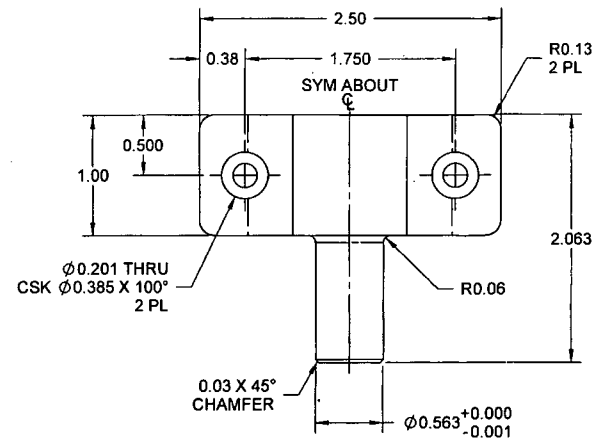
- 1) MATERIAL: BLACK ACETRON GP ACETAL
(REF DART SPEC M-DELIN-B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: SCRIBE WITH DART P/N "D3707-X" USING VIBRATING STYLUS
- 7) WEIGHT: D3707-1 = 0.04 lbs APPROX
D3707-3 = 0.07 lbs APPROX

B	UPDATED NOTE 1 (ZN A8-1)	MB	08.08.22
A	NEW ISSUE	MB	08.04.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.08.22		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3707	REV. B
TITLE MOUNTING LUG	SCALE NTS
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D3707-1 MOUNTING LUG



D3707-3 MOUNTING LUG

RELEASED
69/02/05 MIP

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 400022

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3707	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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